Qty:

Each

20

20 Um:

: CLEVIS

: D2748

: N/A

: 7/20/2006

: D2748 REV A

Date:

Friday, 6/16/2006 1:46:24 PM

User:

Linda Lacelle

: CU-DAR001 Dart Helicopters Services

Customer Job Number : 27560

: 10651 **Estimate Number** :NA P.O. Number

This Issue

S.O. No. : N/A : 6/16/2006

: NC Prsht Rev.

: 6/15/2006 First Issue **Previous Run** 

: PURCHASED PARTS Type

Checked & Approved By

Comment

Written By

: Est. B99.10.27

Now laser cutting EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

**Process Sheet** 

**Drawing Name** 

**Part Number** 

Material

**Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

M304S16GA 1.0

304/316 .063 Sheet



Comment: Qty.:

0.0145 sf(s)/Unit 304/316 .063 Sheet

Total:

0.2900 sf(s)

WATER JET 2.0



Comment: FLOW WATER JET

QC2

SAD INSPECT PARTS AS THEY COME OFF MACHIN



SAD

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.0

QC8

SECOND CHECK



4.0



Comment: SECOND CHECK



5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges after tumbling Bend as per Dwg D2748 using bending jig DT 8289

INSPECT WORK TO CURRENT STEP



6.0

QC5



Comment: INSPECT WORK TO CURRENT STEP



20

Page 1

Date: User:

Friday, 6/16/2006 1:46:24 PM

Linda Lacelle

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: CLEVIS** 

Job Number: 27560

Part Number: D2748

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 5759



8.0



DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



M dede 29

User:

Thursday, 6/15/2006 1:41:35 PM

Kim Johnston

#### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

**Job Number** 

**Estimate Number** 

: 27560 : 10651

P.O. Number

: 6/15/2006 This Issue

: NC Prsht Rev.

: // First Issue

Type

S.O. No. :

: PURCHASED PARTS

**Part Number** 

**Drawing Name** 

: D2748

: CLEVIS

**Drawing Number** 

: D2748 REV A

**Project Number Drawing Revision** 

: N/A : A

Material

**Due Date** 

: 7/20/2006

Qty:

20 Um:

Each

Written By

**Previous Run** 

**Checked & Approved By** 

Comment

: Est.

Now laser cutting

**Additional Product** 

Job Number:



Seq. #:

Machine Or Operation:

Description: PURCHASING

₽G~ 1.0

MATERIAL

M3045&3

Comment: PURCHASING

Issue P/Q:

Laser-Cut-per-Dwg-D2748

Material-release note required

2.0

Clevis

Comment: Qtv.: Glevis-

PACKAGING RESOURCE #1











Recieive & Inspect for Transit Damage Ensure Material Release Note is attached

DIMENSIONAL CHECK







Comment: DIMENSIONAL CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges after tumbling

Bend as per Dwg D2748 using bending jig DT 8289

#### **Dart Aerospace Ltd**

W/O:			V	ORK ORDER CHANGES	3			-	
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
NCR:		V	VORK OR	DER NON-CONFORMAN	CE (NCF	₹)			
		Description of NC Corrective Action Section				Verification		Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description  Design Mgr	Sign 8 Date	sect	tion C	Design Mgr	QC Inspector
							±		

Part No:	PAR #:	Fault Category:	NCR:	Yes (No) DQA:	Date: <u>06/06/28</u>
NOTE: Date & initial all entries				QA: N/C Closed:	Date:

Thursday, 6/15/2006 1:41:35 PM Kim Johnston

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: CLEVIS** 

Job Number: 27560

Part Number: D2748

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

INSPECT WORK TO CURRENT STEP







Comment: INSPECT WORK TO CURRENT STEP

7.0

8.0

PACKAGING 1

Location:\_

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



### **Dart Aerospace Ltd**

W/O:			WO	RK ORDER CHANGES	3			
DATE	STEP	PRO	OCEDURE CHAN	GE	Ву	Date Qty	Approval Mfg / Design Mgr	Approva QC Inspecto
			*					
			·					
		•						
			WORK ORDE	R NON-CONFORMAN	CE (NCD	<u> </u>		
NCR:						·)		
DATE	STEP	Description of NC	Initial	Corrective Action Section B Action Description	Sign &	Verification	Approval	Approval
				Section A	Design Mgr	Design Mgr	Date	Section C
					,			
	·					,		
		· · · · · · · · · · · · · · · · · · ·						
Part No	);	PAR #:	Fault Category	: NCR:	Yes No	DQA:	Date:	
NOTE: D	ate & initia	at all entries			OA: N/C CI	nend:	Date:	

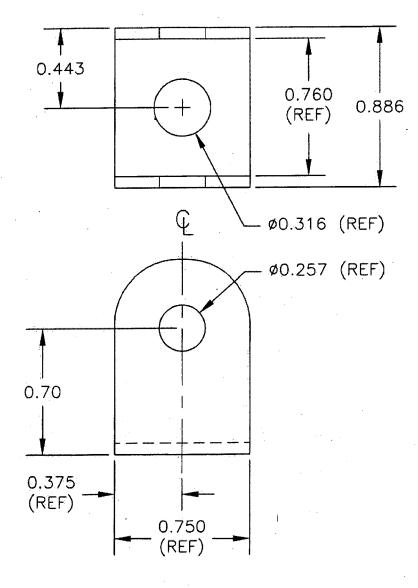
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	<del>  }}</del>	14	D2748	SHEET 1 OF 2
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	99.09.24	•	CLEVIS	2:1
	Α	99.09.24	NEW ISSUE	

# RELEASED 199.10.12 KEE



MATERIAL: AISI 304/316 SS 0.063 THICK USE 0.125 BEND RADIUS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE UNG SUBJ

SHOP COPY

RETURN TO

ENGINEERING

SUBJECT TO AMENDMENT

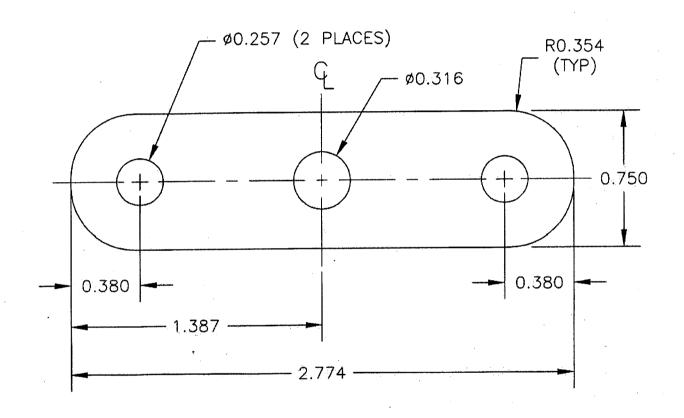
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NO. 27560



DESIGN	DRAWN BY	<b>—</b>	ROSPACE LTD (, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2748	REV. A SHEET 2 OF 2
DATE		TITLE	SCALE
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D2748 FLAT PATTERN

SHOP COPY RETURN TO ENGINEERING

MATERIAL: AISI 304/316 SS 0.063 THICK TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISEN NOTED COPY ALL DIMENSIONS ARE IN INCHES ALL DIMENSIONS ARE IN INCHES

WITHOUT NOTICE

WORK ORDER NO. 27560

DART AEROSPACE LTD	Work Order: 27 560
Description: UNS	Part Number: 72748
Inspection Dwg: , Rev:	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept		Inspection	
0.380	±0,010	0.380			Vern	
1,387	±0,010	1,385	را ا		Vern	
2.774	±0.010	2,774			Vern	
0.380	±0,010	0.382			Vern	
0,750	±0,016	0,756			Verh	
RO.354	20.010	RO.354			R-Garge	
00.316	+0.006/-0.001	0.318			vevn	
00.257	+0.006/-0.001	Ø0.257			Vern	
		·				
*•.						

Measured by:	SAD 186	Audited by:	BU	Prototype Approval:	
Date:	06:06:19	Date:	06.06.19	Date:	

Rev	Date	Change	 Revised by	Approved
Α		New Issue	KJ/JLM	

